

Work Order ID 65669

January 21, 2011 1:44:46 PM

Page 1

Item ID: D4294-1

Accept

Revision ID: ~~PRELIM~~

Item Name: Fitting

Setup Start

Stop

Start Date: 1/21/11

Start Qty: 6.00

Cust Item ID:

Required Date: 2/01/11

Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4294

PA2

100

0.00



Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

Cut Blank to 7.125"

Batch: ~~116867~~

116867

110

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB008

DWG REV: *C*

FOLIO REV: *AA*

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 65669

January 21, 2011 1:44:47 PM

Page 2

Item ID:	D4294-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Fitting					
Start Date:	1/21/11	Start Qty: 6.00		Cust Item ID:		
Required Date:	2/01/11	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>on 11/02/16</i>		<u>2</u>	<u>0</u>		
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>SL 11/02/16</i>		<u>(2)</u>			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>2</u>	<u>0</u>	<i>SL 11/02/16</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65669

January 21, 2011 1:44:47 PM



Page 3

Item ID: D4294-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Fitting

Start Date: 1/21/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/01/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat								
	Powder Coating								
	Memo								
	START: 1:15pm								
	Temp: 320°F								
	Fin: 1:45pm								
150	QC3- Inspect Part Finish	0.00							
	QC								
	Quality Control								
	Memo								
180	Identify as per dwg & Stock Location: _____	0.00							
	Packaging								
	Packaging								
	Memo								

12 16 911/6/11

11/2/11 @

11/2/11 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65669

January 21, 2011 1:44:48 PM



Page 4

Item ID: D4294-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Fitting

Start Date: 1/21/11 Start Qty: 6.00



Cust Item ID:

Required Date: 2/01/11 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/17
MF
11-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 21, 2011 1:44:46 PM

Page 1

Work Order ID: 65669

Parent Item: D4294-1

Parent Item Name: Fitting



Start Date: 1/21/11

Required Date: 2/01/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B4.000x4.00 0		Purchased	No			100	f	1.2578	0.6	3.789474			



7075-T73 Bar 4.0 x 4.0



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	1.2578	
116153	0.2578	
116324	1	

M116867 x 1.1875 *

cmh 11/02/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65669
Description: FITTING		Part Number: D4294-1
Inspection Dwg: D4294 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.25	$\pm .030$.250	—		Vern	ML-2
3.375	$\pm .030$	3.375	—		"	"
4.875	$\pm .010$	4.875	—		"	"
1.670	$\pm .010$	1.670	—		"	"
Ø.386	$\pm .006$	Ø.387	—		"	"
Ø.266	$\pm .006$	Ø.270	—		"	"
6.81	$\pm .030$	6.810	—		"	CNL-02
6.35	$\pm .030$	6.355	—		"	"
3.440	$\pm .010$	3.440	—		"	"
1.46	$\pm .036$	1.458	—		"	ML-7
4.968	$\pm .010$	4.967	—		"	"
Ø.875	$\pm .010$	Ø.877	—		"	"
Ø.750	$\pm .010$	Ø.752	—		"	"
.332	$\pm .020$.332	—		"	"
.691	$\pm .010$.695	—		"	"
8°	$\pm 1/2°$	8°	—		C-Square	ML-CBB
1.405	$\pm .010$	1.403	—		Vern	ML-7
Ø.381	$\pm .006$	Ø.381	—		"	"
1.125	$\pm .010$	1.125	—		"	"
6.49	$\pm .030$	6.490	—		"	"
R.13	$\pm .030$	R.125	—		Rad-gage	REF
.64	$\pm .030$.632	—		Vern	ML-7
2.15	$\pm .030$	2.145	—		"	"

Measured by:	amf
Date:	11/02/16

Audited by:	SL
Date:	11/02/16

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD		Work Order: 65669
Description: FITTING		Part Number: D4294-1
Inspection Dwg: D4294 Rev: C		Page 1 of 1

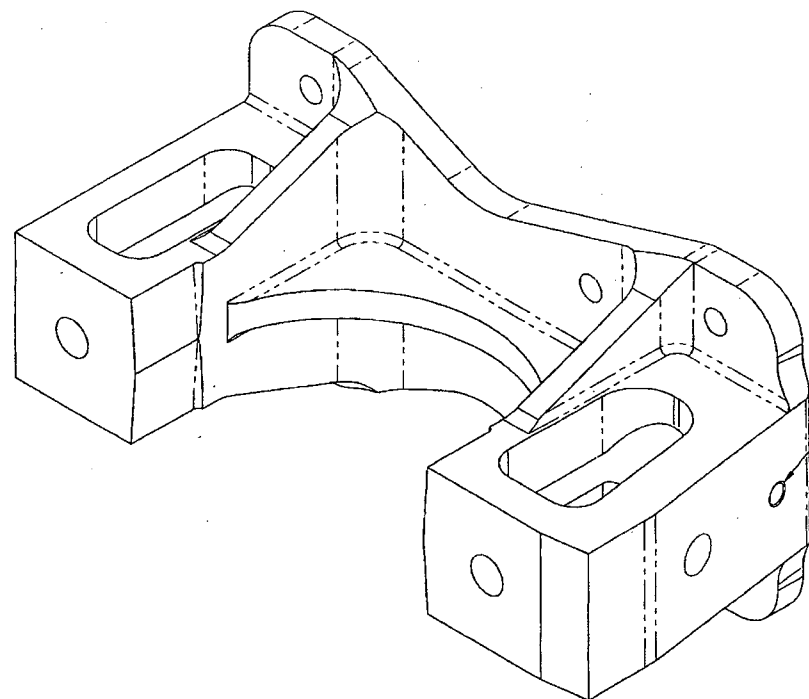
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.065	± 0.010	.062	—		UCLA	ML-7
.305	± 0.030 ± 0.010	.305	—		"	"
3.17	± 0.030	3.170	—		"	"
3.11	± 0.030	3.112	—		"	"
.325	± 0.010	.328	—		"	"
.780	± 0.010	.778	—		"	"
.80	± 0.030	.782	—		"	"
1.560	± 0.010	1.560	—		"	"
.500	± 0.010	.499	—		"	"
.070	± 0.010	.065	—		"	"
.39	± 0.030	.393	—		"	"
.82	± 0.030	.800	—		"	"
.500	± 0.010	.500	—		"	"
.88	± 0.030	.880	—		"	"
.764	± 0.010	.765	—		"	"
$\varnothing .201$	± 0.005 ± 0.001	$\varnothing .201$	—		"	"
$\varnothing .320 \times 100^\circ$	± 0.006 ± 0.001 $\times \frac{1}{2}^\circ$	$\varnothing .327 \times 100^\circ$	—		"	"
3.44	± 0.030	3.447	—		"	"
2.450	± 0.010	2.450	—		"	"
2.04	± 0.030	2.059	—		"	"
1.528	± 0.010	1.533	—		"	"
.300	± 0.010	.305	—		"	"
.738	± 0.010	.738	—		"	"

Measured by: <i>ank</i>	Audited by: <i>SL</i>	Preliminary Approval:
Date: 11/02/16	Date: 11/02/16	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D4294-1 FITTING

RELEASED
2011-02-01

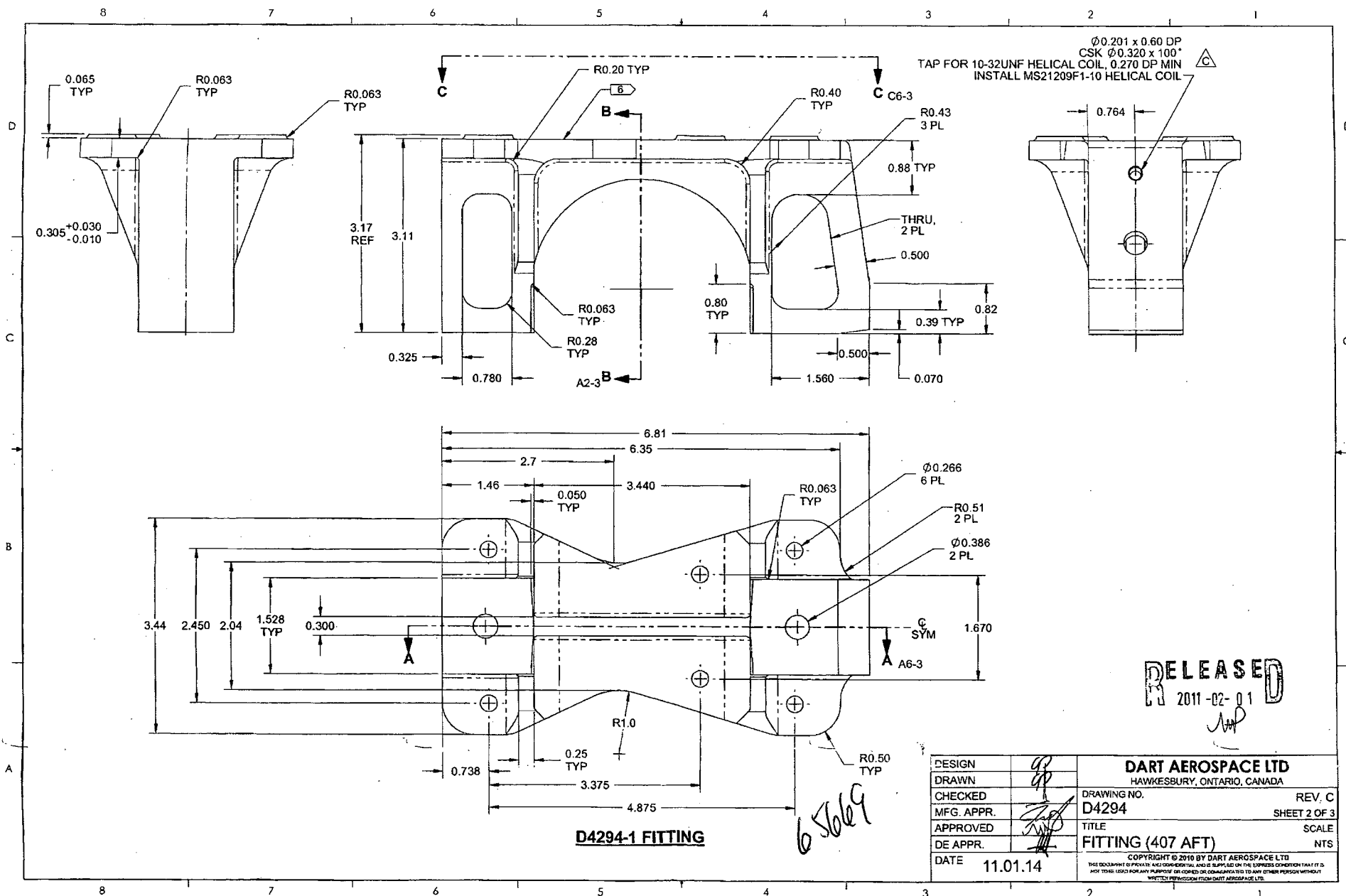
NOTES:

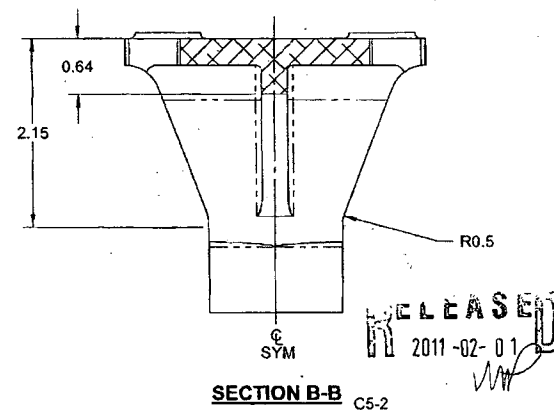
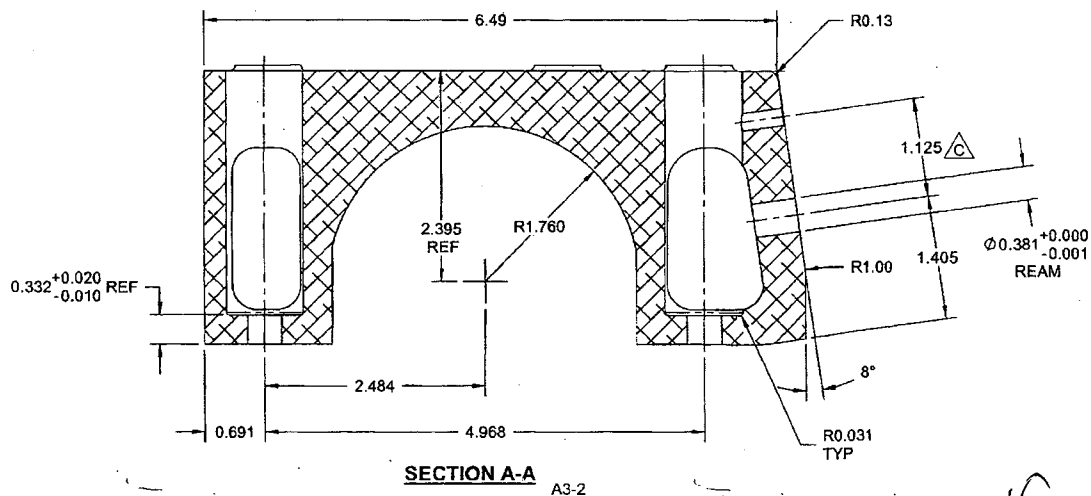
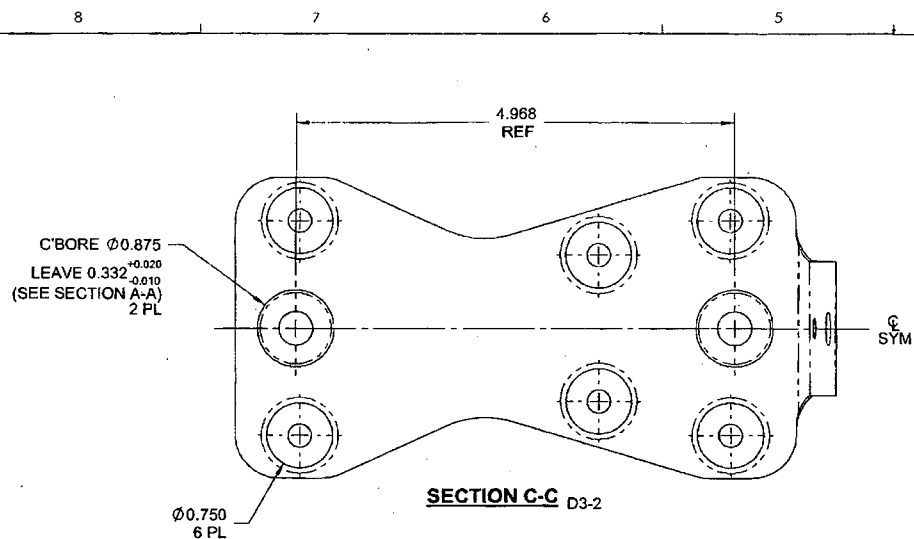
- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 C.A.R.
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4294-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.55 lbs

who 65669

C	ADD HELICAL COIL (D1-2, B4-3)	CP	11.01.14
B	0.780 WAS 0.75 (C6-2), 1.580 WAS 1.54 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.01.14		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4294	REV. C
TITLE FITTING (407 AFT)	SCALE NTS
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DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4294	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FITTING (407 AFT)	NTS
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65669